

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125249

Tuesday, October 07, 2014 10:39:11 AM

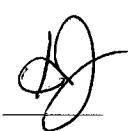
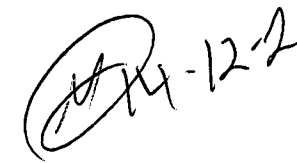
125249

Page 2

Item ID: D412-704-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot Emergency Cargo Release
Start Date: 9/29/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/06/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging			50		(1x)	DAS 46		DEC 02 2014
Packaging	Memo	0.00					9-89		
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: <u>FC-017 18</u> PPP Rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/12/2 
 12-2

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:39:10 AM

Page 1

Work Order ID: 125249

125249

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot Emergency Cargo Release

Start Date: 9/29/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC
REV:B 12.04.20 per cen-566 DD verf:EC
12.05.10 per ECN 12-583 DD verf:EC
IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-704-141 *D412-704-141* Pedal Assembly DAS 46 9-89		Manufactured	No			110	Each	2.0000	1	1		DAS 27 9-89	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST203	1							
					116090	1							
					ST230	1							
					119629	1							
D412-704-045 *D412-704-045* Cable Ass'y DAS 46 9-89		Manufactured	No			110	Each	6.0000	1	1		DAS 27 9-89	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST221	1							
					123413	1							
					ST221A	1							
					120322	1							
					ST223	4							
					115994	3							
					116959	1							
D3207-5 *D3207-5* Bracket DAS 46 9-89		Manufactured	No			110	Each	30.0000	1	1		DAS 27 9-89	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST028	30							
					101658	1							
					115759	7							
					116991	22							

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Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:39:10 AM

Page 3

Work Order ID: 125249

125249

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot Emergency Cargo Release

Start Date: 9/29/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

D3208-3 Manufactured No

110 Each 27.0000

D3208-3
Pedal Mount Angle

DAS
46
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

ST029

27

117181
119885

20

7

****** **U** 1

DAS
27

9-89
11/12/14

D3208-7 Manufactured No

110 Each 28.0000

D3208-7
Filler

DAS
46
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

ST029

20

119559

20

ST202

8

101715

8

****** **U** 1

DAS
27

9-89
14/12/14

D3208-9 Manufactured No

110 Each 6.0000

D3208-9
Doubler

DAS
46
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

ST029

6

115866

6

****** **U** 1

DAS
27

9-89
14/12/14

D3214-1 Manufactured No

110 Each 7.0000

D3214-1
Decal

DAS
46
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

ST029

7

117068

7

****** **U** 1

DAS
27

9-89
14/12/14

Tuesday, October 07, 2014 10:39:10 AM

Shop Packet Print

Page 3

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, October 07, 2014 10:39:10 AM

Page 4

Work Order ID: 125249

125249

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot Emergency Cargo Release

Start Date: 9/29/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

D4610-1 Manufactured No

110

Each

3.0000

1 1

D4610-1

Doublet

DAS
38
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

Return2014

1

103804

1

ST110

2

103804

1

104412

1

**

DAS
27
9-89

14/12/14

D4610-3 Manufactured No

110

Each

6.0000

1 1

D4610-3

Doublet

DAS
38
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

ST110

6

98863

6

**

DAS
27
9-89

14/12/14

D4610-7 Manufactured No

110

Each

3.0000

1 1

D4610-7

Cover

DAS
38
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

ST110

3

84418

3

**

DAS
27
9-89

14/12/14

MS21919-DG5 Purchased No

110

Each

65.0000

4 4

MS21919-DG5

Clamp

DAS
38
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

ST300

65

110916

2

m128401

8

m128813

25

m129499

30

**

DAS
27
9-89

14/12/14

Tuesday, October 07, 2014 10:39:10 AM

Shop Packet Print

Page 4

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, October 07, 2014 10:39:10 AM

Page 5

Work Order ID: 125249

125249

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot Emergency Cargo Release

Start Date: 9/29/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

D4622-1 Manufactured No

110

Each

7.0000

1

1

D4622-1

Placard

DAS
46
9-89

DAS
38
9-89

Location

ST111

Loc Qty

7

Loc Code

103540

7

**

DAS
27
9-89

4/12/01

D4622-3 Manufactured No

110

Each

5.0000

1

1

D4622-3

Placard

DAS
46
9-89

DAS
38
9-89

Location

ST111

Loc Qty

5

Loc Code

103632

4

83749

1

**

DAS
27
9-89

4/12/01

MS35489-149 Purchased No

110

Each

128.0000

1

1

MS35489-149

GRÖMME

DAS
46
9-89

DAS
38
9-89

Location

ST281

Loc Qty

128

Loc Code

121692

128

**

DAS
27
9-89

4/12/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

DEC 01 2014

DAS

46

9-89

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		☒					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		(1)		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		(1)				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		(1)					D3207-5	BRACKET
1	1	(1)					D3207-7	PACKER
		(1)					D3207-9	BRACKET
1		(1)					D3207-11	BRACKET
1	1	(1)					D3208-1	DOUBLER (OR ECM 999709-1)
1		(1)					D3208-11	FILLER
1	1	(1)					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	(1)					D3208-7	FILLER (OR ECM 999709-3)
1		(1)					D3208-9	DOUBLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	(1)					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		(1)					D4610-1	DOUBLER
		(1)					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		(1)					D4610-7	COVER
				1			D4611-1	BUSHING
		(1)					D4622-1	PLACARD
		(1)					D4622-3	PLACARD
			1	1			AN3-10A	BOLT
					1	1	AN3-13A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT

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Revision: C

Date: 12.04.12

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DEC 01 2014

DAS

46

9-89

IIN-D412-704

Page 17 of 17

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20002-4	WASHER
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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Revision: C

Date: 12.04.12

Work Order ID 125249

Tuesday, October 07, 2014 10:39:11 AM

125249

Page 1

Item ID: D412-704-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Emergency Cargo Release
 Start Date: 9/29/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/06/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-10-08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
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MLS 14-12-01

DAS
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DEC 01 2014

